

**Work Order ID 51829**

September 4, 2009 9:14:16 AM



Page 1

Item ID: D3846-3

Accept



Setup Start



Revision ID: B

Stop



Item Name: GASKET

Start Date: 09/04/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: mfDate: 09-09-04 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3846

B

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3848

Dwg Rev: BProg Rev: B

2-Deburr if necessary

IB 9-9-10

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

IB 9-9-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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September 4, 2009 9:14:16 AM



Page 2

Item ID: D3846-3

Accept



Setup Start



Revision ID: B

Stop



Item Name: GASKET

Start Date: 09/04/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00

2) 8/25/10

QC

Memo

0.00



Quality Control

130

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

9/9/10 (82) SP

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

09/09/11 DJ

Quality Control

W 9-09-11

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**NOTE:** Date & initial all entries

# Picklist Print

September 4, 2009 9:14:16 AM

Page 1

Work Order ID: 51829

Parent Item: D3846-3RevB

Parent Item Name: GASKET

Comments:

Start Date: 09/04/2009

Required Date: 09/11/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	496.5411	4.6463	71.6157	9.2926	
NEOPRENE SHEET 0.063											B 9-9-16	

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

496.5410585

111469

71.1

111853

96.7589585

112508

328.6821

N/A  
N/A  
112508

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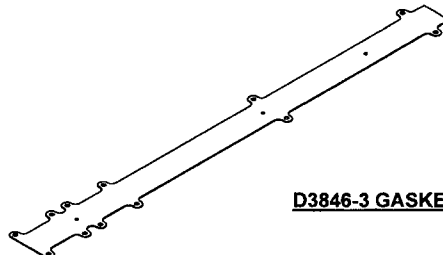
**NOTE:** Date & initial all entries



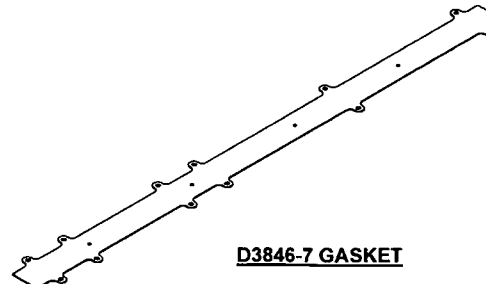
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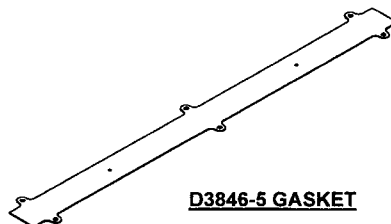
D3846-1 GASKET



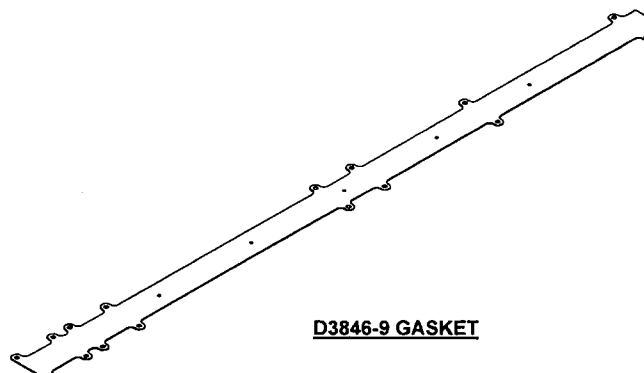
D3846-3 GASKET



D3846-7 GASKET



D3846-5 GASKET



D3846-9 GASKET



D3846-11 GASKET

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 51829  
MF 09-09-04

RELEASED  
09/17/15

NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 0.063 THICK, 60 DUROMETER  
(REF. DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3846-X" USING YELLOW PAINT MARKER
- 7) WEIGHT:  
D3846-1 = 0.03 lbs  
D3846-3 = 0.25 lbs  
D3846-5 = 0.20 lbs  
D3846-7 = 0.26 lbs  
D3846-9 = 0.35 lbs  
D3846-11 = 0.04 lbs

B	5.82 WAS 6.25 (ZN C4-2); 45.28 WAS 45.71 (ZN A4-3); 6.32 WAS 6.75 (ZN B2-3)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3846	SHEET 1 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	GASKET	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1



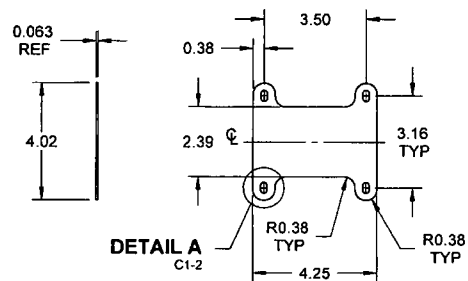
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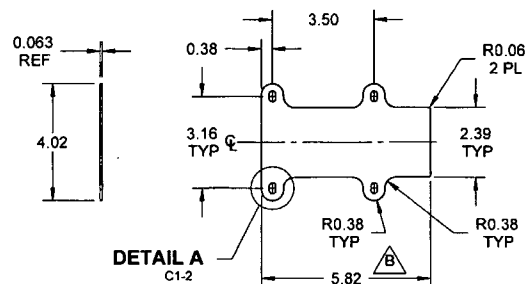
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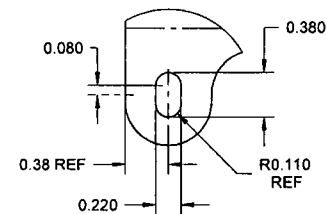
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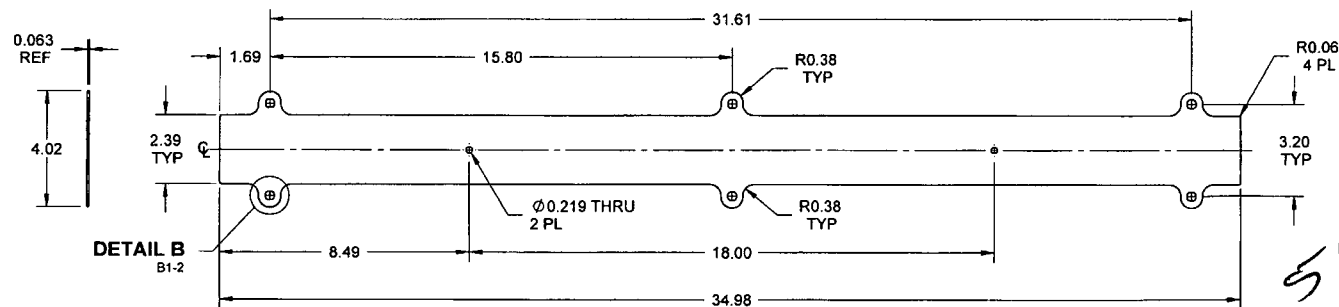
**D3846-1 GASKET**



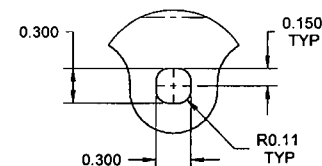
**D3846-11 GASKET**



**DETAIL A** C5-2  
TYP. SCALE 4X C7-2



**D3846-5 GASKET**



**DETAIL B** A7-2  
TYP. SCALE 4X B7-3  
C5-4

**RELEASED**  
09/07/15 NW

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	PH	<b>D3846</b>	SHEET 2 OF 4
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	<b>GASKET</b>	NTS
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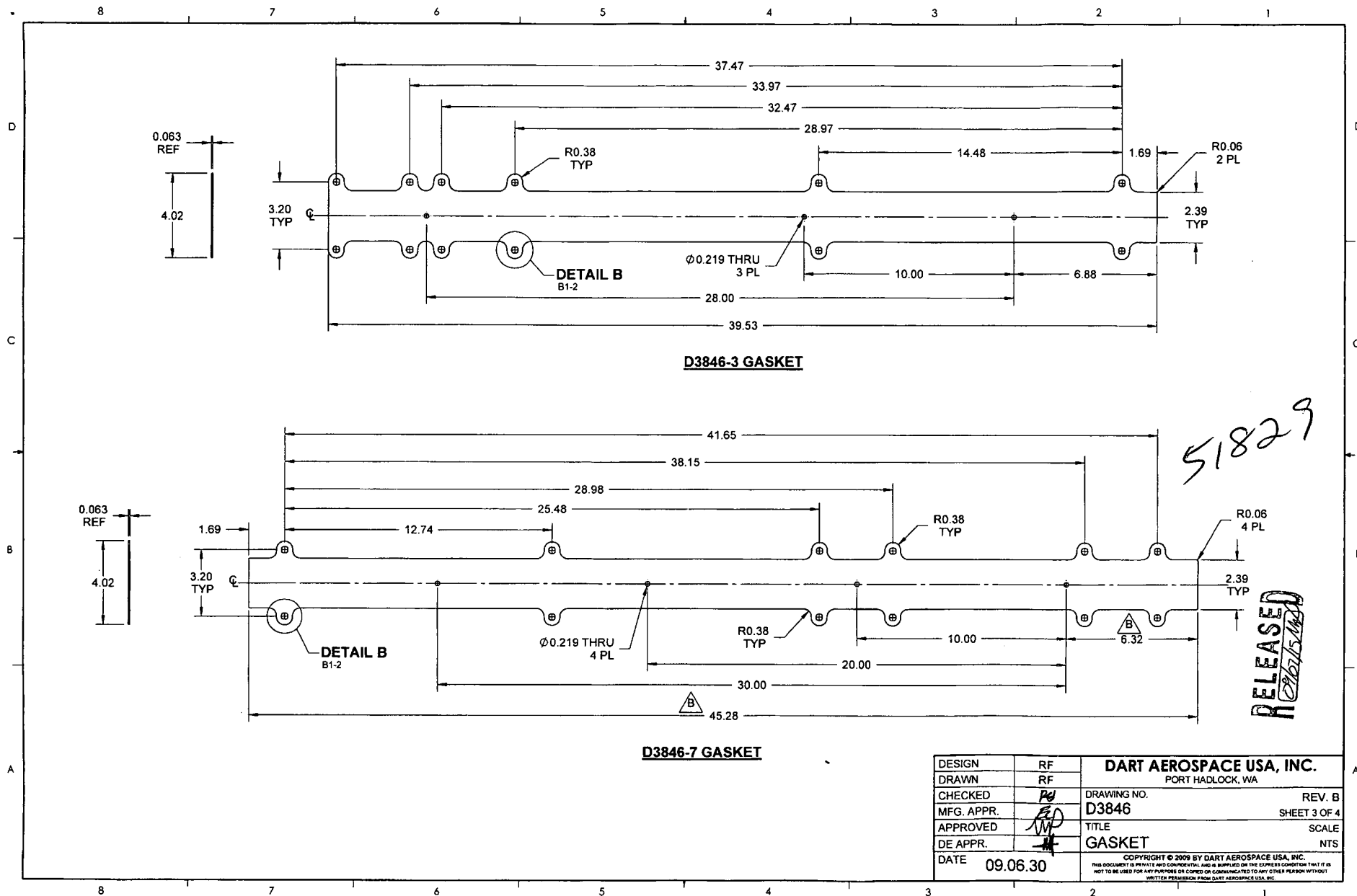
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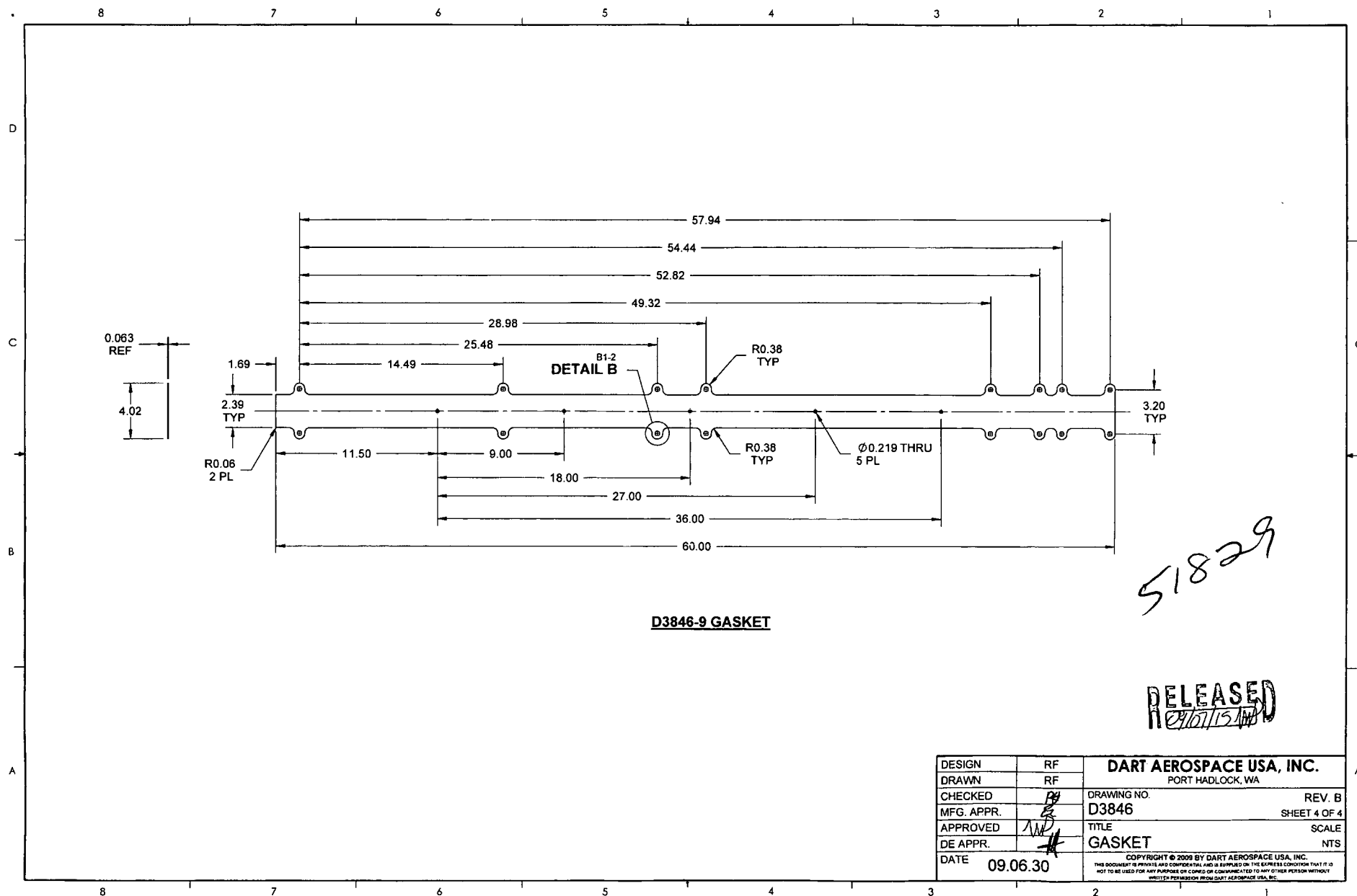
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